

# ANODE WIRE FRAME VISUAL INSPECTION AND TENSION TEST

RECC	RD ANODE WIRE WINDING NUMBER #	
RECC	ORD WHICH SPOOLS WIRE WERE USED:#	
After	answering each of the following questions please initial your na	me.
VIS	UAL INSPECTION	
1.	Is there kink in the wires?	Yes, No
2.	Are any wires contaminated with oil, dirt, and/or lint?	Yes, No
3.	Are there any discolorations of the wire?	
		Yes, No
4.	Are there any missing wires in the wire frame?	Yes, No
5.	Are there any epoxy drippings on wound wires?	Yes, No
6.	Is insufficient epoxy applied at both ends of the wires to fixed the	em in the
	position? (The minimum width of epoxy to be applied at both ends shall be	e specified
	by Jon Wirth )	Yes, No
7.	Are there any loose wire? (check this without using Laser Wire Tension Scanner)	Yes, No
	IF THE ANSWER TO ANY QUESTION ABOVE IS <b>YES</b> BAWIRE FRAME <b>"REJECTED-VISUAL"</b> AND NOTIFY COGNIZANT ENGINEER.	G AND TAG Y

DIMENSION					
Take a th	ole ANODE nree adjacent the frame)	WIRE winding space at measurements at	pacing is $4 \text{ mm} \pm 1$ three locations (be	1 center to center other ends and at t	he
Does wire spa	acing of the	wire winding faile	d to meet the requ	irement?	
1	O	J	1	Yes	No
			e winding does not wire frames also d		ncing
f item 8 is mark REJECTED D notify cognizant	IMENSION	g and tag all six w	ire frames from sa in "reject storage",	me winding , and	
PENICIONI T	TECT				
<u> TENSION T</u>	ESI				
			ninimum of ten sa ibuted sample re		
Vire Number		Frequency read	ng (Hz)	Tension (Newto	ons)
•		Frequency read	<u>ng (Hz)</u>	Tension (Newto	ons)
•		Frequency readi	ng (Hz)	Tension (Newto	ons)
		Frequency read	ng (Hz)	Tension (Newto	ons)
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Vire Number		Frequency read	ng (Hz)	Tension (Newto	ons)

## **INSTRUCTIONS**

If item 9 is marked <u>No.</u> tag and bag all six wire frames from same winding "**REJECTED TENSIONS**" and mark below and put them in "reject storage". If item 9 is marked <u>YES</u>, attach this inspection record and place wire frame inside of LEXAN storage/transporter box.

(Note: When storing the wire frames inside of LEXAN storage/transporter box, **do not put traveler inside of the box**. Place them outside of the LEXAN box).

PASSED	 REJECTED			
Inspector's signature	Inspection date:	/	/199	



# ANODE WIRE FRAME PRIOR TO USE CHECK VISUAL INSPECTION

VIDU	AL MOI ECTION	
RECO	RD ANODE WIRE WINDING NUMBER #	_
After :	answering each of the following questions please initial your na	ne.
<u>VISU</u>	JAL INSPECTION	
1.	Is there kink in the wires?	Yes, No
2.	Does any wire contaminated with oils, dirts, and/or lint?	Yes, No
3.	Are there any discolorations of the wire?	
		Yes, No
4.	Are there any missing wires in the wire frame?	Yes, No
5.	Are there noticeable change in the wire tension? (Look for sags or noticeable catenary effect)	Yes, No
6.	Are there any broken wires?	Yes, No
	IF THE ANSWER TO ANY QUESTION ABOVE IS <u>YES</u> BAG wire frame with "REJECTED-VISUAL" AND NOTIFY COGNIZANT ENGINEER.	
INST	CRUCTIONS	
	al inspection has failed, bag and tag "REJECTED WIRE FRAME and put them in "reject storage area".	" and mark
	PASSED REJECTED	
Inspect	tor's signature Inspection date:/_	/199

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ANO]	DE WIRE S CHECK	
SECTO	OR type: Outer Inner Strongback Serial No	
SECT	COR SERIAL No.:	
After a	answering each of the following questions please initial your nan	ne.
	JAL INSPECTION AFTER ANODE WIRES ARE	2
1.	Is there kink in the wires?	Yes, No
2.	Does any wire contaminated with oils, dirts, and/or lint?	Yes, No
3.	Are there any discolorations of the wire?	
		Yes, No
4.	Are there any missing wires in the wire frame?	Yes, No
5.	Are there noticeable change in the wire tension? (Look for sags or noticeable catenary effect)	<b>Yes</b> , No
6.	Are there any broken wires?	Yes, No
	IF THE ANSWER TO ANY QUESTION ABOVE IS <u>YES</u> BAG wire frame with "REJECTED-VISUAL" AND NOTIFY COGNIZANT ENGINEER.	
INST	<u>TRUCTIONS</u>	
If visua below	al inspection has failed, bag and tag "REJECTED WIRE FRAME and put them in "reject storage area".	" and mark
	PASSED REJECTED	
Inspect	tor's signature Inspection date:/_	_/199_

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# SHIELD WIRE AND GATED GRID WIRE FRAME VISUAL INSPECTION AND TENSION TEST

After the each answer of following questions please initial your name.	
RECORD WHICH SPOOLS' WIRE WERE USED:#	
RECORD SHIELD WIRE /GATED GRID WIRE WINDING NUMBER #	Ä

### **VISUAL INSPECTION**

1.	Is there kink in the wires? (check every spools)	Yes, No
2.	Does any wire contaminated with oils and dirts (include lint)?	Yes, No
3.	Are there any discoloration of the wire?	
		Yes, No
4.	Are there any missing wire in the wire frame?	Yes, No
5.	Are there any epoxy dripping on wounded wires?	Yes, No
6.	Are not enough epoxy applied at both ends of the wires? (The minimum width of epoxy to be applied at both ends shall be by Jon Wirth)	specified
		Yes, No
	IF THE ANSWER TO ANY QUESTION ABOVE IS <u>YES</u> BAC wire frame with "REJECTED-VISUAL" AND NOTIF	

#### **DIMENSIONAL INSPECTION**

7. SHIELD WIRE/GATED GRID WIRE winding spacing should be 1.0 mm  $\pm$  0.3 center to center.

Take a three adjacent measurements at three locations (bother ends and at the center of the frame)

Are spacing	of the	wire	winding	failed to	meet	the	requirement?
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Yes	NT-
Yes	. No

**NOTE:** If one out of six wire frame from same winding does not meet the spacing requirement we can assume that the other five wire frames also do not meet the spacing requirement.

If item 7 is marked <u>YES</u>, bag and tag all six wire frames from same winding "REJECTED DIMENSIONS" and put them in "reject" storage.and notify cognizant engineer

### **TENSION TEST**

Using Laser Tension Scanner take minimum of twenty sample wire tension readings and record them. Try to take distributed sample readings from one wire frame.

Wire Number	]	Frequency	reading (Hz	Y categories August Aug	Tension (Ne	ewtons)
1	-					
2	٠-				Secretary	anterate
4	-				s self also	
5	ş		M. KW h			
6 7	-				planesus its	(11 <sub>2</sub> - 2, 11 - 11 - 11)
8.						
9	-					
10 11	_					
12.						
13.	-	*			· 18 : ***********************************	
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18 19	-					
<u>20.</u>	-					FA MENES
21	e. 1 - <u>-</u>				· · · · · · · · · · · · · · · · · · ·	

The tension of all wires on the frame should be 1.20 Newtons  $\pm$  0.06

	Yes, <b>No</b>
INSTRUCTIONS	
is marked <u>YES</u> , attach this inspection recestorage/transporter box.	low and put them in "reject" storage. If item 8 ord and place them inside of LEXAN de of LEXAN
	•
PASSED	REJECTED
Inspectors signature	Inspection date://199

Did sample tension measurement stay within the specified tension limit?

8.

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